

Date: Monday, 11/28/2005 10:26:39 AM  
 User: Linda Lacelle

## Process Sheet

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b>	: SADDLE, INBOARD, LS, 206
<b>Job Number</b>	: 24849		
<b>Estimate Number</b>	: 10820		
<b>P.O. Number</b>	: N/A	<b>Part Number</b>	: D26661
<b>This Issue</b>	: 11/28/2005	<b>S.O. No.</b>	: N/A
<b>Prsht Rev.</b>	: NC	<b>Drawing Number</b>	: D2666 REV. B
<b>First Issue</b>	: N/A	<b>Project Number</b>	: N/A
<b>Previous Run</b>	: 23922	<b>Drawing Revision</b>	: B
	<b>Type</b> : MACHINED PARTS	<b>Material</b>	: N/A
<b>Written By</b>	: SEE COMMENT BELOW	<b>Due Date</b>	: 12/5/2005
<b>Checked &amp; Approved By</b>	: SEE COMMENT BELOW	<b>Qty:</b>	12
<b>Comment</b>	: Est: C 00.11.01 Removed P/O for Powder Coat - in house processEC		

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	D6101001	7075-T7351 2X6X6.25
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total: 12.0000 Each(s)

7075-T7351 2X6X6.25

Issue material from stock:

Cut Size 2.0 x 6.25 X 6.0

Grain Along Long 6.0 Length

Batch No: B24820 Ep 06/01/04

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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**Comment:** HAAS CNC VERTICAL MACHINING #1

Program batch number. Ep 06/01/04

1-Inspect part number and batch number are programmed correctly. MS 06/01/04

2-Fixturing W/O No. N/A

3-Fixturing Inspection last completed on 06/01/04 by Ep

4-Machine Step No 1 of Folio and visually inspect as per attached Dimension Sheet

5-Machine Step No 2 of Folio and visually inspect as per attached Dimension Sheet

6-Machine Step No 3 of Folio and visually inspect as per attached Dimension Sheet

7- Deburr

Ep 1

06/04/14

Ep pm 06/01/07 12

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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**Comment:** CONVENTIONAL MILLING MACHINE

Machine Keyway and inspect per attached dimension sheet

Ep 06/01/14

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

Ep 06/01/14 / pm 06/01/07 12

Date: Monday, 11/28/2005 10:26:40 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE, INBOARD, LS, 206

Job Number: 24849

Part Number: D26661

Job Number:



Seq. #:	Machine Or Operation:	Description :
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5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

5.0. 06/01/14

6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

SAD 06 01 14

7.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

FC 06 01 17

8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT

MA 06 01 17

9.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 364

C2 06/01/18 (12)

10.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Inspection Level 21

SAC 06/01/19 (12) SP 06/01/19

Job Completion



<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	<b>24849</b>
<b>Description:</b> 206 Saddle, Inboard, Left side	<b>Part Number:</b>	<b>D2666-1</b>
<b>Inspection Dwg:</b> D2666 Rev. B		<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2666 Rev. B and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		0.126	0.120	0.121	0.122		
B	0.100	0.140		0.124	0.120	0.120	0.123		
C	0.100	0.140		0.121	0.125	0.123	0.123		
D	0.210	0.230		0.216	0.219	0.215	0.216		
E	1.245	1.255		1.247	1.246	1.249	1.247		
F	1.245	1.255		1.247	1.246	1.249	1.247		
G	5.990	6.010		6.002	6.004	6.004	6.002		
H	0.510	0.515		0.512	0.512	0.512	0.512		
I	1.674	1.684		1.678	1.678	1.677	1.678		
J	2.495	2.505		2.499	2.498	2.499	2.498		
K	0.257	0.262	DT8683	0.259	0.259	0.259	0.259		
L	0.312	0.317	DT8686	0.312	0.312	0.312	0.312		
M	0.235	0.240		0.238	0.238	0.237	0.238		
N	0.100	0.140		0.117	0.118	0.119	0.118		
O	0.540	0.560		0.544	0.544	0.543	0.548		
P	0.490	0.510		0.497	0.498	0.498	0.496		
Q	3.609	3.619		3.611	3.610	3.611	3.611		
R	2.470	2.510		2.500	2.500	2.500	2.500		
S	0.240	0.270		0.249	0.250	0.246	0.246		
T	0.100	0.180		0.140	0.138	0.140	0.140		
U	0.313	0.318	DT8686	0.318	0.318	0.318	0.318		
V	1.125	1.145		1.133	1.134	1.133	1.133		
W	1.565	1.585	DT8695 A/B	-	-	-	-		
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	<i>Sp</i>
Date:	06/01/05

Audited by:	<i>J.G.</i>
Date:	06/01/14

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	<b>24849</b>
<b>Description:</b> 206 Saddle, Inboard, Left side	<b>Part Number:</b>	<b>D2666-1</b>
<b>Inspection Dwg:</b> D2666 Rev. B		<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2666 Rev. B and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		0.124	0.125	0.123	0.124		
B	0.100	0.140		0.123	0.124	0.124	0.122		
C	0.100	0.140		0.117	0.116	0.114	0.113		
D	0.210	0.230		0.217	0.217	0.221	0.222		
E	1.245	1.255		1.248	1.249	1.250	1.250		
F	1.245	1.255		1.248	1.249	1.250	1.250		
G	5.990	6.010		6.003	6.001	6.001	6.001		
H	0.510	0.515		0.512	0.512	0.512	0.512		
I	1.674	1.684		1.678	1.677	1.678	1.678		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262	DT8683	0.259	0.259	0.258	0.258		
L	0.312	0.317	DT8686	0.312	0.312	0.312	0.312		
M	0.235	0.240		0.237	0.238	0.238	0.238		
N	0.100	0.140		0.118	0.118	0.123	0.124		
O	0.540	0.560		0.547	0.548	0.548	0.549		
P	0.490	0.510		0.500	0.500	0.500	0.497		
Q	3.609	3.619		3.611	3.611	3.610	3.612		
R	2.470	2.510		2.500	2.500	2.506	2.500		
S	0.240	0.270		0.248	0.249	0.250	0.250		
T	0.100	0.180		0.146	0.143	0.146	0.150		
U	0.313	0.318	DT8686	0.318	0.318	0.318	0.318		
V	1.125	1.145		1.133	1.133	1.136	1.137		
W	1.565	1.585	DT8695 A/B	-	-	-	-		
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: <i>mt</i>	Audited by: <i>3.6</i>
Date: <i>06/01/07</i>	Date: <i>06/01/14</i>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	24049
<b>Description:</b> 206 Saddle, Inboard, Left side	<b>Part Number:</b>	D2666-1
<b>Inspection Dwg:</b> D2666 Rev. B		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2666 Rev. B and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		0.125	0.123	0.126	0.126		
B	0.100	0.140		0.124	0.123	0.122	0.122		
C	0.100	0.140		0.115	0.111	0.110	0.112		
D	0.210	0.230		0.222	0.220	0.219	0.219		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	5.990	6.010		6.001	6.001	6.001	6.001		
H	0.510	0.515		0.512	0.512	0.512	0.512		
I	1.674	1.684		1.678	1.678	1.678	1.678		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262	DT8683	0.259	0.259	0.259	0.259		
L	0.312	0.317	DT8686	0.312	0.312	0.312	0.312		
M	0.235	0.240		0.237	0.238	0.238	0.239		
N	0.100	0.140		0.122	0.127	0.126	0.124		
O	0.540	0.560		0.550	0.550	0.549	0.547		
P	0.490	0.510		0.502	0.501	0.503	0.504		
Q	3.609	3.619		3.611	3.611	3.611	3.611		
R	2.470	2.510		2.500	2.500	2.500	2.500		
S	0.240	0.270		0.247	0.246	0.245	0.245		
T	0.100	0.180		0.150	0.150	0.149	0.150		
U	0.313	0.318	DT8686	0.318	0.318	0.318	0.318		
V	1.125	1.145		1.138	1.139	1.137	1.138		
W	1.565	1.585	DT8695 A/B	-	-	-	-		
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									



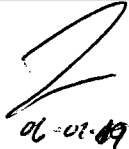


Measured by: *SM*  
Date: 06/01/07 / 06/01/14

Audited by: *SG*  
Date: 06/01/14

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: 12 Date: 06/01/19  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06.01.09	2	There is a 0.030" x 0.095" chamfer on some DZ666-7 saddles, on bottom edge below the slot for the skid tube ridge	 06.01.09 PM 051042	Parts are O.K. Problem identical to <del>2002</del> DZ666-2 parts approved by DS b/N 24582	 06/01/02	 06-01-09	 06.01.09 PM 051042	 06-01-19

NOTE: Date & initial all entries

## Chris Provencal

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**From:** David Shepherd [davids@dartaero.com]  
**Sent:** January 9, 2006 5:18 PM  
**To:** Chris Provencal  
**Subject:** Re: Saddle NCR

Chris,

I think the 0.030 x 0.095 chamfer described below is acceptable because this still leaves about 0.220" of material below the saddle slot. Therefore, these parts are acceptable.

David

----- Original Message -----

**From:** "Chris Provencal" <cprovencal@dartaero.com>  
**To:** <davids@dartaero.com>  
**Sent:** Monday, January 09, 2006 2:51 PM  
**Subject:** Saddle NCR

> David,  
>  
> The problem is regarding the D2666-2 saddles. There's qty (3) like the  
> picture from the previous email. There is a chamfer that was put on the  
> bottom edge, near the slot for the skidtube ridge. The chamfer is 0.030"  
> towards the slot for the skidtube ridge, and I measure 0.095" along the  
> bottom edge.  
>  
>  
>  
> Sincerely,  
> Chris Provencal  
> DART Aerospace Ltd.  
> Email..cprovencal@dartaero.com  
> Phone...613-632-3336  
> Fax.....613-632-4443  
>  
>